

Date: Friday, 18/07/2008 1:10:20 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CABIN FLOOR PROTECTOR
<b>Job Number</b> :	40647		
<b>Estimate Number</b> :	12765		
<b>P.O. Number</b> :		<b>Part Number</b> :	D35744
<b>This Issue</b> :	18/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3574 REV.A
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	35865	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	31/07/2008
<b>Written By</b> :		<b>Qty:</b>	2
<b>Checked &amp; Approved By</b> :	JUD 08.7.18	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev :A New Issue 07-01-22 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
-----	------------------	-------------------------



**Comment:** Qty.: 33.6000 sf(s)/Unit Total: 67.2000 sf(s)  
 lexan sheet  
 Batch: 105330 HB 8-7-22

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3574  
 Dwg Rev: A  
 Prog Rev: A

HB 8-7-22



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S 08/07/23 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 08/07/23 (2)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 18/07/2008 1:10:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 40647

Part Number: D35744

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/28* *(2)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

*RRP4063*

*08/07/28*

*(2)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/28* *(2)*

Job Completion



*MF 08-07-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40647
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-4
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 1 of 3</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.004/-0.001	1.09	*		Tape Measure	
Ø3.00	+0.006/-0.001	3.003	*			
1.25	+/-0.030	1.25	*			
7.62	+/-0.030	7.62	*			
10.25	+/-0.030	10.25	*			
11.87	+/-0.030	11.87	*			
14.75	+/-0.030	14.75	*			
26.00	+/-0.030	26.00	*			
34.13	+/-0.030	34.13	*			
40.87	+/-0.030	40.87	*			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	*			
55.13	+/-0.030	55.13	*			
59.50	+/-0.030	59.50	*			
59.75	+/-0.030	59.75	*			
61.25	+/-0.030	61.25	*			
61.88	+/-0.030	61.88	*			
64.63	+/-0.030	64.63	*			
2.00	+/-0.030	2.00	*			
7.38	+/-0.030	7.38	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
17.62	+/-0.030	17.62	*			
25.87	+/-0.030	25.87	*			
34.25	+/-0.030	34.25	*			
34.94	+/-0.030	34.94	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
51.00	+/-0.030	51.00	*			

S0017/03

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 400047
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-4
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 2 of 3</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
58.38	+/-0.030	58.38	*		Ipsa name	
61.25	+/-0.030	61.25	*			
63.43	+/-0.030	63.43	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
1.13	+/-0.030	1.13	*			
3.13	+/-0.030	3.13	*			
7.63	+/-0.030	7.63	*			
8.13	+/-0.030	8.13	*			
11.00	+/-0.030	11.00	*			
14.50	+/-0.030	14.50	*			
15.75	+/-0.030	15.75	*			
18.40	+/-0.030	18.40	*			
22.10	+/-0.030	22.10	*			
22.50	+/-0.030	22.50	*			
24.50	+/-0.030	24.50	*			
25.50	+/-0.030	25.50	*			
30.75	+/-0.030	30.75	*			
34.00	+/-0.030	34.00	*			
35.13	+/-0.030	35.13	*			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.50	+/-0.030	41.50	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			
44.70	+/-0.030	44.70	*			
3.70	+/-0.030	3.70	*			
6.06	+/-0.030	6.06	*			

08/17/23

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40647
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-4
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 3 of 3</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

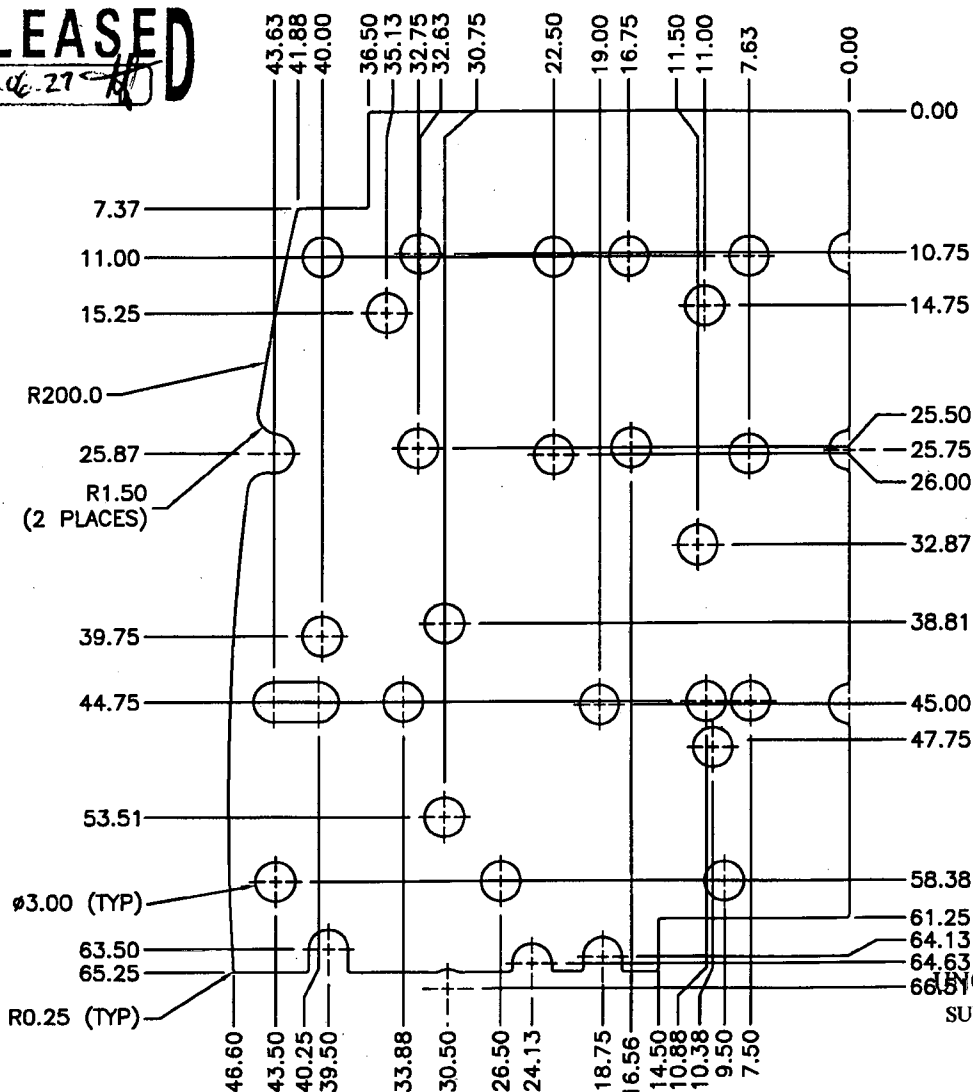
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	+/-0.030	6.75	*		Tape measure	
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
14.50	+/-0.030	14.50	*			
16.75	+/-0.030	16.75	*			
18.94	+/-0.030	18.94	*			
19.00	+/-0.030	19.00	*			
24.13	+/-0.030	24.13	*			
33.88	+/-0.030	33.88	*			
35.75	+/-0.030	35.75	*			
36.13	+/-0.030	36.13	*			
39.50	+/-0.030	39.50	*			
40.25	+/-0.030	40.25	*			
43.50	+/-0.030	43.50	*			
43.90	+/-0.030	43.90	*			
46.60	+/-0.030	46.60	*			

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-7-22	<b>Date:</b> 08/17/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD [Signature]	[Signature]

**DART**

DESIGN <b>LE</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>H</b>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

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07.06.27

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**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

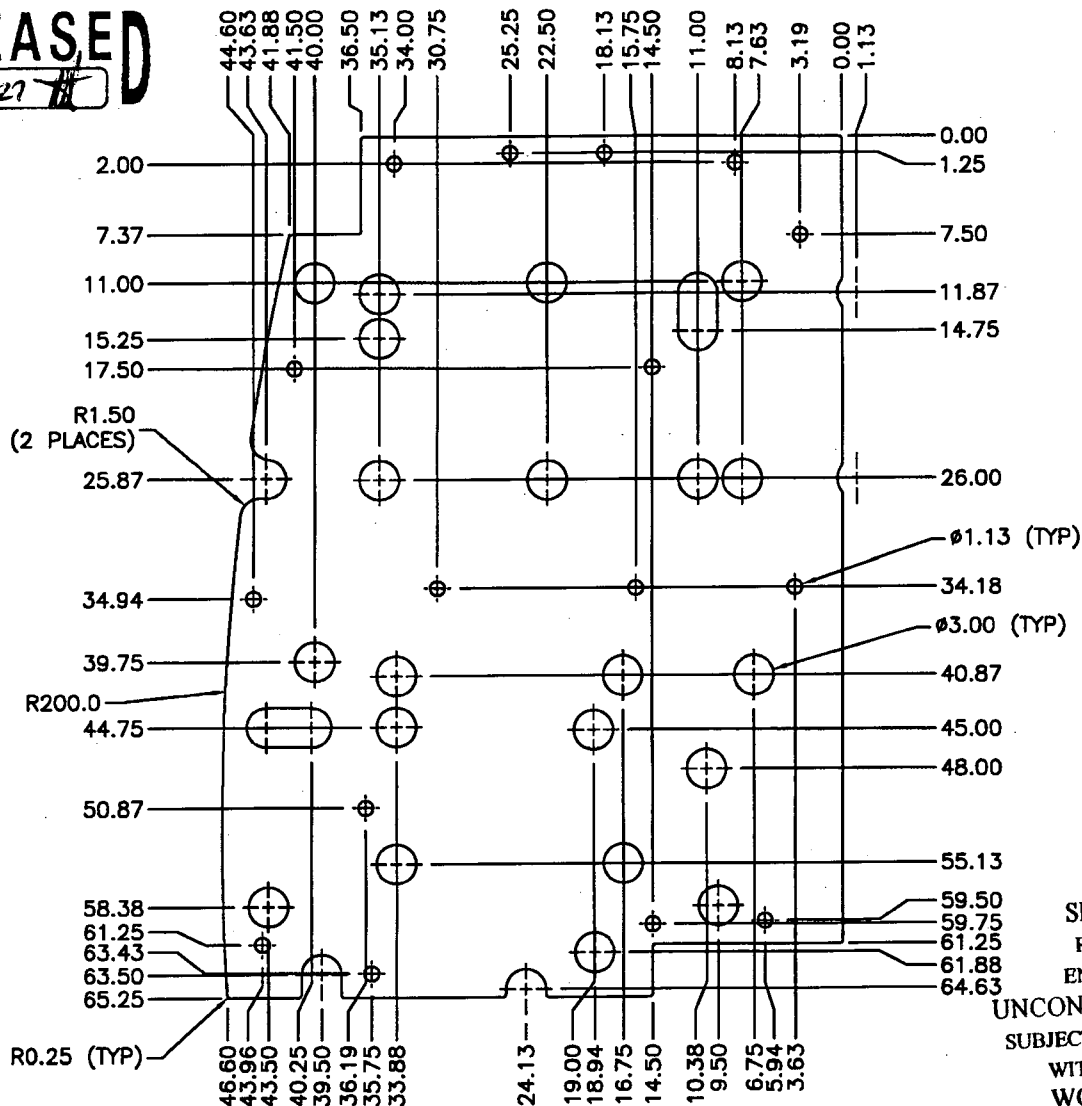
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

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**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

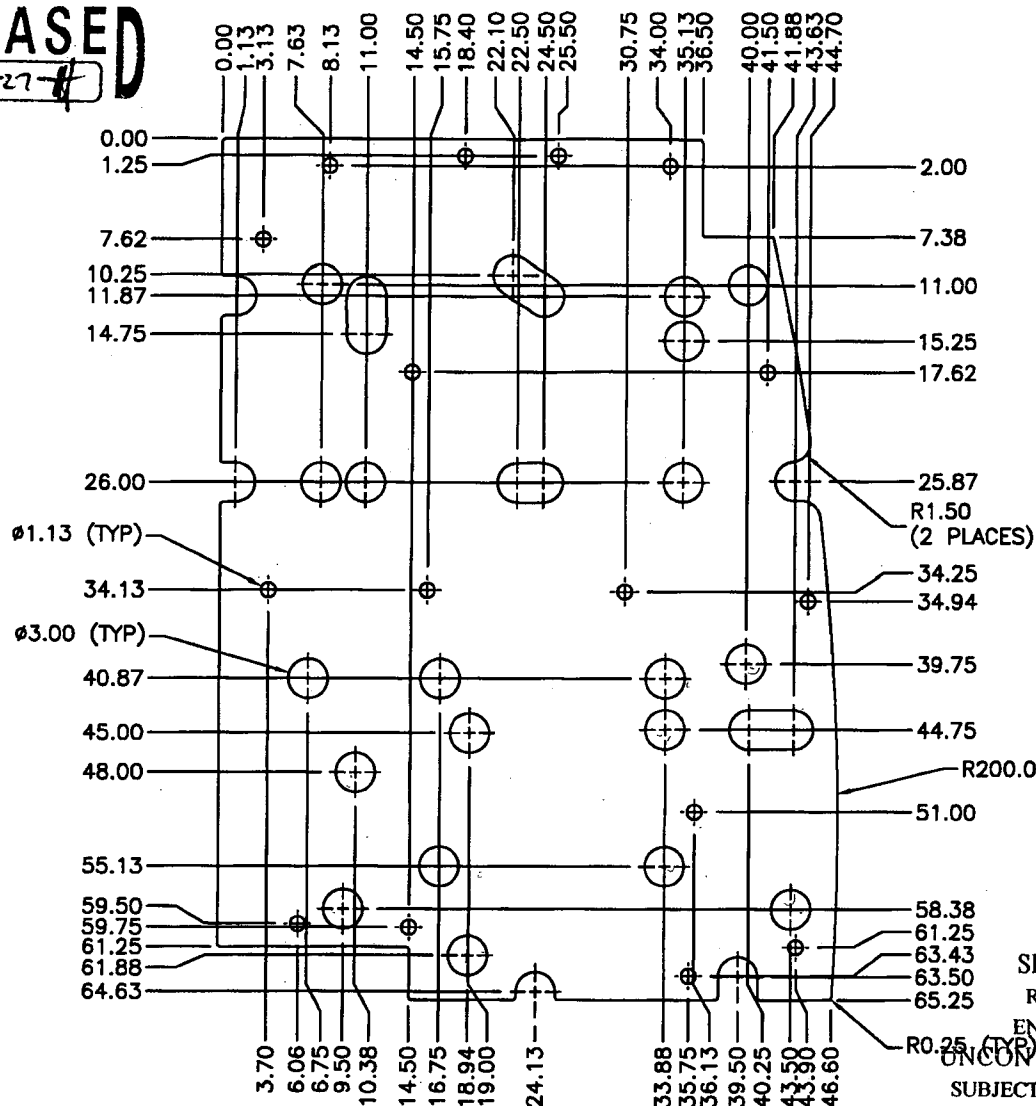
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

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07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

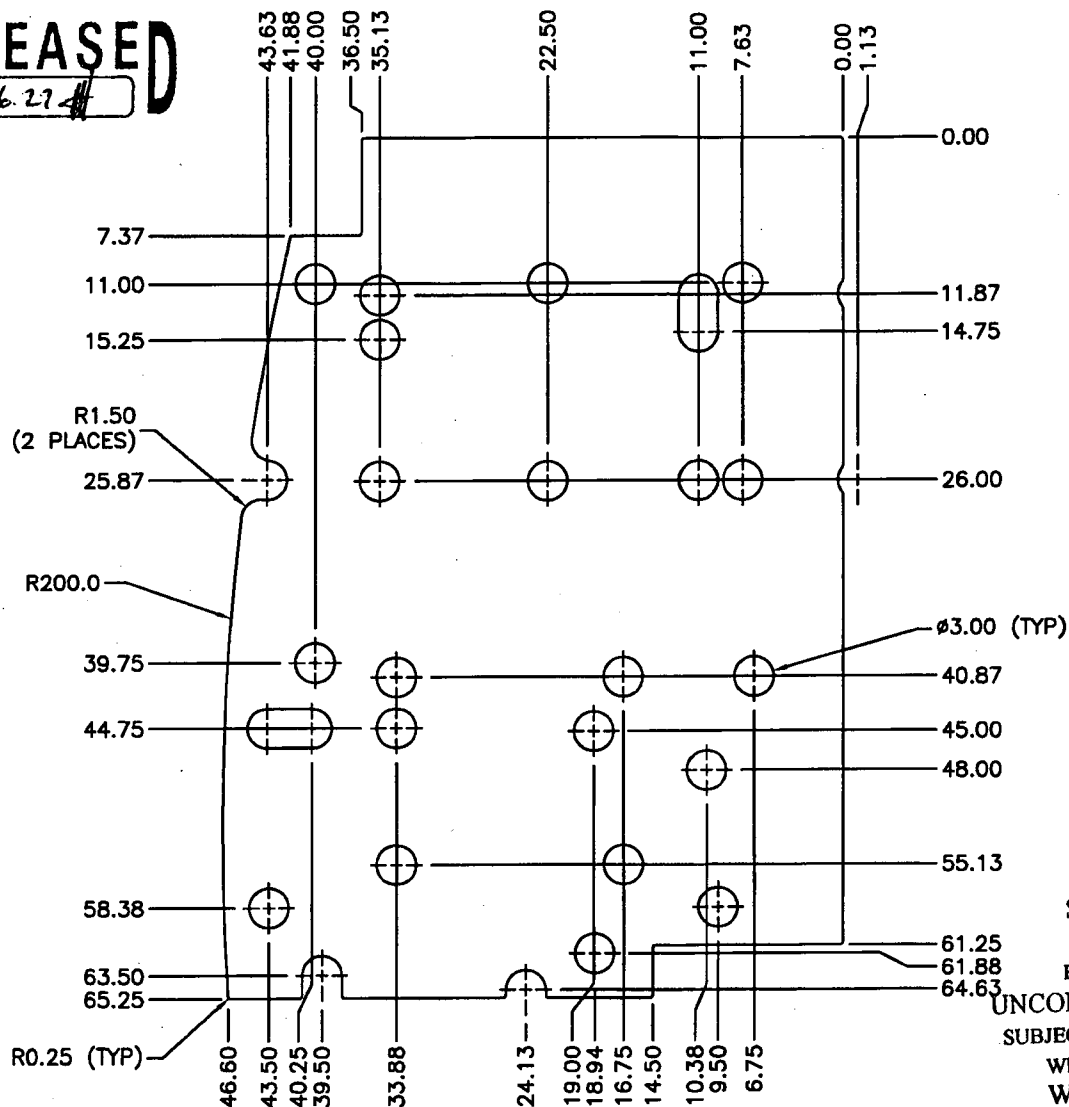
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

**RELEASED**  
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

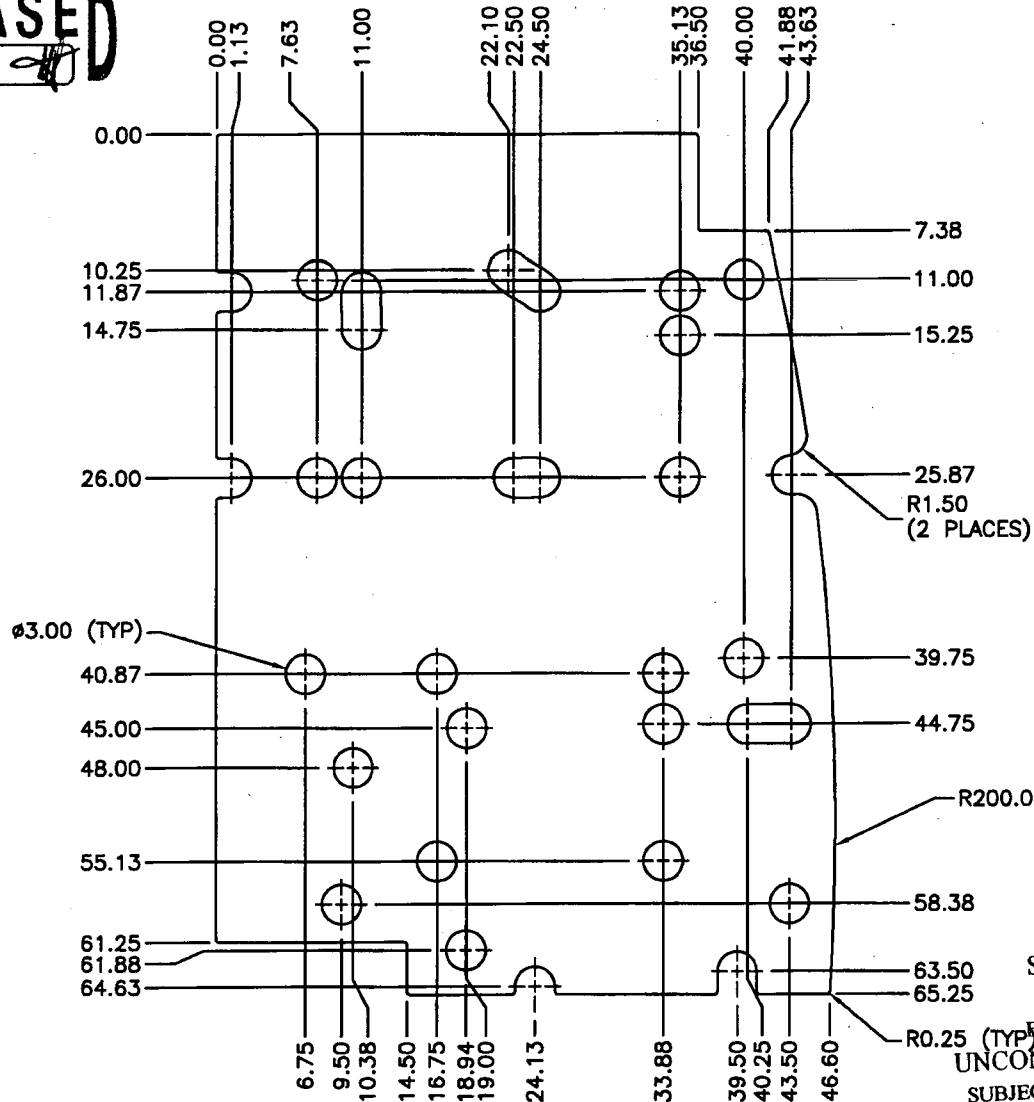
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

**RELEASED**  
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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